Work Order ID 107279 September-23-13 11:46:25 AM				*107	279*				2.4.4.4.		Page 1
Revision ID:	D3875-1 Floor Protector	_		Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Sta Sto	1/1	S1*
Start Date: 9/18/13 Start Qty: 1.00 Required Date: 9/23/13 Req'd Qty: 1.00		*1* *1*		Cust Item ID: Customer:					IN	<b>.</b>	
Reference: Approvals:		n: MLJ				ate:		R	tun Sta	"IVI	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		sion Nbr									
D3875 100 *100* HandThermo Hand Finishing Therm	Rev	Мето	eet to required Blank size	0.00 0.00	51			-x l			OAG 07 2-89
105 *105* HandThermo Hand Finishing There	moforming	Dry Material  Memo Dry Sheet Temp: Time IN:_	t as per QS1022 POLYCARBO 240 F 7:00 pm T: 7:00 am	, 1				×-l			DAG 07 )

												DQA:	Date	e:	
NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE		•		•	
												QA Closed:	Date	e:	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
Work Orac	•••					Rework	1		Skid-tube	Crosstube		1	Water Jet		Engineering
Part N	۱o.					Scrap	1		Machining	Small Fab	$\overline{}$	Pro	d. Eng. Coor.		Quality
					:	Use-as-is	]	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	۱o.					Work Order Update	]		Large Fab	Composite			Supplier		
Root				1	Descri	tion of work order update	Т	Initial	Λ.	tion		Sign &		_	
Cause		Date	Step	Qty	1	or Non-conformance		iief Eng		cription		Date	Verification		QC Inspector
Doc/Data		Date	Step	Qty	`	or Non-comormance	-	iter Ling	Desc	прион	_	Date	Verification	_	QC IIISPECTOI
Equip/Tooling															
Operator															
Material															
Setup															
Other														ļ	
Process							1								
Supplier															
Training															
Unapproved							<u> </u>								
						F	AUL	T CATE	GORY						
Landi	ng (	Gear				General	_	-		•		<b>-</b>	-		
		Bending				Bend		Grain			<u>_</u>	Ovalized			Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	L	Hardwa	re		_	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged	1	Inspect	ion Incomplete		i	Part Incorred	t I		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

<b>Work Ord</b> September-23-1				*107	279*							Page 2
Item ID: Revision ID: Item Name:	D3875-1 Floor Protecto	or		Accept	*N900	<u>040</u>	100	<b>)</b> *	Setup	Start Stop	171	S1* S2*
Start Date:	9/18/13	Start Qty: 1.00	*1*		Cust Item	ID:						
Required Date: Reference:	9/23/13	Req'd Qty: 1.00	*1*		Customer:							
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:		]	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*110* Thermoform Thermoforming Ma	chine	Memo 1-Machine S 2-Pre-heat T 3-Thermofor Dwg Rev: Folio Rev:	ool to required temp. rm as per Dwg and Folio	0.00 o #FTA0xxusing tool DT9435	·							13/10/02
		Visually insp	pect for proper formatio	n and texture								
140				0.00				ı				
*140* HandThermo Hand Finishing The	rmoforming	Memo 1-Trim to fir	nished dimensions as pe	0.00 r Dwg				<u>-¥_(_</u>		· • - • · · · · · · · · · · · · · · · ·		13/10/02
150 *150*		QC2- Inspect parts off m	achine FAI/FAIB	0.00				<b>x</b> (				Sl.
QC		Memo		0.00								11/-

Quality Control

Complete FAI document

DQA:	Date:	

## **WORK ORDER NON-CONFORMANCE / UPDATE**

NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Engineering Skid-tube Crosstube Water Jet Rework Part No. Machining Small Fab Prod. Eng. Coor. Quality Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Initial Action Sign & Root Verification Date Step Qty or Non-conformance Chief Eng Description Date QC Inspector Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bend Grain Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Maintenance Part Moved Contamination Countersink Mislabeled Positioned Wrong Heat Treat Cut Too Short Misread Power Loss/Surge Other Inspection Strip in Tube **Drill Holes** Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration

Out of Sequence

Outside Dimensions

**Turning Sequence** 

Wave/Twist in Tube

Finish

Folio

<b>Work Ord</b> September-23-1				*107	7279*							Page 3	
Item ID: Revision ID: Item Name: Start Date: Required Date	D3875-1  Floor Protecto 9/18/13 : 9/23/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	Accept	*N900 Cust Item Customer	ID:	100	*	Setup	Start Stop	171.	S1* S2*	_
Reference: Approvals:		in:				Date:			Run	Start Stop	171	R1* R2*	
Sequence ID/ Work Center I 160 *160* QC Quality Control	D	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Hours  0.00 DAS 27 9-89	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp	_
170 <b>*170*</b> Packaging Packaging		Identify as per dwg & Sto	ock Location:	0.00 1 X PP	P 1059	169		_1\			(3	DAS 26 9-89	_
180 *180* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00				4	4/	/ pl	13-10- M	-10 K	

Quality Control

13-10-09

DQA:_		Date:	
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NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

										QA Closed:	Dat	e:
Work Orde	r.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0	<u> </u>			Use-as-is Work Order Update	1		noforming Large Fab	FinishingComposite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		1				1						
Operator												
Material												
Setup												
Other						ł						
Process												
Supplier												
Training												
Unapproved												
					F	AULT	CATE	GORY				
Landir	ng Gear				General					-	_	
	Bending				Bend	Щ	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/	Crimped			Burrs		nstruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at		ļ	Countersink	∐ r	Mislabe	led	<u></u>	Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge [	Other
	Ripples in	Bend		<u> </u>	Drill Holes	Щ	Offset					
	Torque W	/aves in E	xtrusio	n [_	Drawing	$\square$	Out of C	Calibration				
	Turning S	equence			Finish		Out of S	Sequence				
[	Wave/Tw	ist in Tub	oe .		Folio	$\Box$	Outside	Dimensions				

**Picklist Print** 

September-23-13 11:46:24 AM

Work Order ID:

107279

Parent Item:

D3875-1

Parent Item Name:

Floor Protector

**Start Date: 9/18/13** 

Required Date: 9/23/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev. A 09.02.06 New Issue DL

IPP Rev.B Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 Lexan Sheet		Purchased	No			100	sf	288.8680	9.84	9.84			Dh
Lexan Shoet				Location		Loc Qty	Lo	c Code				(	3/10/6
				therm	127	288.868 288.868				9,84	57 ft		, (

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** Yes / No NCR: QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Skid-tube Engineering Crosstube Water Jet Rework Part No. Machining Small Fab Prod. Eng. Coor. Quality Scrap **Thermoforming** Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Sign & Action Initial Root Chief Eng Description Verification Date Step Qty or Non-conformance Date QC Inspector Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Bend Pressure/Forced Bending Grain BOM/Route Centre Not Concentric to O/S Over/Under tolerance Hardware Temperature/Cure Broken/Damaged Weld Cracks Inspection Incomplete Part Incorrect Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Ripples in Bend **Drill Holes** Offset

Out of Calibration

Out of Sequence

**Outside Dimensions** 

**Turning Sequence** 

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	107 279
Description: Floor Protector	Part Number:	D3875-1
Inspection Dwg: D3875 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than What				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				
Measured by:	]		Date:	13/0/02
TRIMMING	SECTIO	N		· /

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.0674	~		CALTHOT	
0.080	Min	0.088"			CALTH-DT	
45.2	+/-0.100	45.2"			[APEDLO]	
22.3	+/-0.100	22.3"	V		TAPE FLOI	
1.4	+/-0.100	1.344			Uniber	<u> </u>
Measured	bv. b)	J.	<u> </u>	<del></del>	Date:	13/10/03

DAS/A Date: Audited by: Date: Preliminary Approval:

Rev	Date	Change	Revised	рy	Approved
Α	09.09.15	New Issue	KJ		- 11
В	13.05.08	Dimensions updated per Dwg Rev B	KJ ~	X	(8)
L			•	$\langle \ / \ \rangle$	,

